

June 27

26

Date: Thursday, 6/7/2007 3:31:56 PM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|---------------------------------------|------------------|---|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : HELI UTILITY BASKET, LIGHTWEIGHT, SHORT |
| Job Number | : 32863 | | |
| Estimate Number | : 12245 | | |
| P.O. Number | : N/A | Part Number | : D350721043 |
| This Issue | : 6/7/2007 | S.O. No. | : N/A |
| Prsht Rev. | : NC | Drawing Number | : N/A |
| First Issue | : N/A | Project Number | : N/A |
| Previous Run | : 32862 | Drawing Revision | : N/A |
| | | Material | : N/A |
| Written By | : | Due Date | : 6/26/2007 |
| Checked & Approved By | : <u>980706.08</u> | Qty: | 1 Um: Each |
| Comment | : Est A 05.02.09 New issue KJ/JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D350-721-043 CHG001

KS 07.08.11

| | | |
|-----|--------|----------------------|
| 2.0 | 32863A | BASKET BASE ASSEMBLY |
|-----|--------|----------------------|



Comment: Sub-Component BASKET BASE ASSEMBLY

D3326-041 B 32863A

ml 07/06/21

| | | |
|-----|--------|---------------------|
| 3.0 | 32863B | BASKET LID ASSEMBLY |
|-----|--------|---------------------|



Comment: Sub-Component BASKET LID ASSEMBLY

D3327-041 B 32863B

ml 07/06/21

| | | |
|-----|-------------|-----------------------|
| 4.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Pick: Assembly Kit

| | | |
|-----|----------|--------|
| 5.0 | D2022101 | Spacer |
|-----|----------|--------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2022-101 Spacer 1530543

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Thursday, 6/7/2007 3:31:56 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET, LIGHTWEIGHT, SHORT

Job Number: 32863

Part Number: D350721043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2332041

Lid Prop Assembly 6.69"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

D2332-041

1 D2530

Handle Assembly

B31105

7.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 D2530

Handle Assembly

B31106

8.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 D2535

Spring

B28363

9.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 D2537

Bushing

B31107

10.0

D27291

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Assembly Kit

Qty Part Number

Description Batch

1 D27291

Label

11.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 D2931

Bumper

B21139

OK ✓
CP 07/06/180

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Date: Thursday, 6/7/2007 3:31:56 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET, LIGHTWEIGHT, SHORT

Job Number: 32863

Part Number: D350721043

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D3320043

Webbing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 D3320-043

Webbing

B 32864

13.0

D33511

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 D3351-1

Label

B31664 -

14.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN3-16A

Bolt

M103691 -

15.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN4-7A

Bolt

M102140 -

16.0

AN420A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 AN4-20A

Bolt

M116895 -

17.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 AN4-22A

Bolt

M1104214 -

EP 7/6/18 @

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET, LIGHTWEIGHT, SHORT

Job Number: 32863

Part Number: D350721043

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN5-17A

Bolt M103962 -

19.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN960JD416

Washer M103691 -

20.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN960JD416L

Washer M103962 -

21.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN960JD516

Washer M103641 -

22.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN960JD8

Washer M104156 -

23.0

AN960JD9

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

24 AN960JD9

Washer M16499 -

CP 07/06/180

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET, LIGHTWEIGHT, SHORT

Job Number: 32863

Part Number: D350721043

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN970-4

Washer

1103344

25.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

24 MS20600AD4W3

Rivet

1102929

26.0

MS20600AD4W2

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 MS20600AD4W2

Rivet

114747

27.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 MS21042L3

Nut (or -3)

1103691

28.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 MS21042L4

Nut (or -4)

1102552

CP 07/06/180

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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Date: Thursday, 6/7/2007 3:31:56 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET, LIGHTWEIGHT, SHORT

Job Number: 32863

Part Number: D350721043

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 MS21042L5 Nut (or -5) M102536 -

Handwritten signature and date: 07/06/18

30.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg IIN-D350-721

Attach Travelers:

Handwritten note: mul 07/06/27

31.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten note: 07/06/27

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

33.0

D22301

Mounting Lug



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

3 D2230-1

Lug

B30992 ✓

34.0

D22303

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 D2230-3

Clamp

B30993 ✓

35.0

D2856400

Abrasion Strip



Comment: Qty.: 2.5200 f(s)/Unit Total : 2.5200 f(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

Handwritten signature and date: 07/06/18

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Thursday, 6/7/2007 3:31:56 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET, LIGHTWEIGHT, SHORT

Job Number: 32863

Part Number: D350721043

Job Number:



Seq. #:

Machine Or Operation:

Description :

4 D2856-4007.20" Abrasion Strip B32020 ✓

36.0

D33381

Mounting Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D3338-1

Lug

B23797 ✓

37.0

D3350041

Strut Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 D3350-041

Strut

B32590 ✓

38.0

AN412A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 AN4-12A

Bolt

M103962 ✓

39.0

AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN4-13A

Bolt

M104418 ✓

40.0

AN414A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 AN4-14A

Bolt

M102473 ✓

JPB 07/06/180

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 2 Date: 17/04/29
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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Date: Thursday, 6/7/2007 3:31:56 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET, LIGHTWEIGHT, SHORT

Job Number: 32863

Part Number: D350721043

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

AN960JD416

Washer



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

28 AN960JD416

Washer

1103691 ✓

42.0

MS21042L4

Nut



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

16 MS21042L4

Nut (or -4)

1102552 ✓

EP 07/06/180

43.0

QC4

INSPECT, 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

07/06/27 (1)

U 07-06-27

44.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-721-043

Location: _____

PPP Rev: _____

07/06/27 (1)

SP

45.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/29 (1)

Job Completion



U 07-06-28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Process Sheet

26

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BASKET BASE ASSEMBLY
 Job Number : 32863A
 Estimate Number : 11331
 P.O. Number : N/A Part Number : D3326041
 This Issue : 6/7/2007 S.O. No. : N/A Drawing Number : D3326 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : B
 Previous Run : 32862A Material : N/A
 Due Date : 6/26/2007 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : 07/06/08
 Comment : Est A 05.02.09 New issue KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M4130NTS0500W035 4130 Square tube .5 x .5



Comment: Qty.: 32.2875 f(s)/Unit Total : 32.2875 f(s)
 Material: 4130 Cond. N Square tube per MIL-T-6736, 1/2" x 0.035" wall
 (M4130N-TS0.500W.035)
 Identify parts appropriately M116550 07/06/11

2.0 M569EX05018F 569 Expanded Metal



Comment: Qty.: 0.0061 sf(s)/Unit Total : 0.0061 sf(s)
 Pick:
 Qty Part Number Description Batch
 28s M569EX0.50-18F 1/2"-18gauge(.040") carbon steel M104613 07/06/12

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
 1-Cut tubes as per Dwg D3326

| Qty | Part Number | Description | Batch |
|-----|-------------|------------------|--------|
| 2 | D3328-3 | Hinge Plate | B32847 |
| 4 | D3348-1 | Clevis | B32587 |
| 2 | D3349-3 | Spacer Bushing | B32589 |
| 2 | D3367-1 | Mounting Bracket | B32478 |

Identify parts appropriately

07/06/12

2-Remove all markings from material and deburr as required check for foreign objects.

3-Drill and Weld as per Dwg D3324 & QSI 004
 A/RN/Steel Rod M102226

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 01/06/09
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY

Job Number: 32863A

Part Number: D3326041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Deburr as required

4.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-06-14 (1)

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 07-06-14 (1)

6.0

POWDER COATING

POWDER COATING



M104144



(1)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M-L 07/06/16

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 07/06/21

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

ml 07/06/21

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(1)

Comment: FINAL INSPECTION/W/O RELEASE

ml 07/06/29

Job Completion



W 07-26-28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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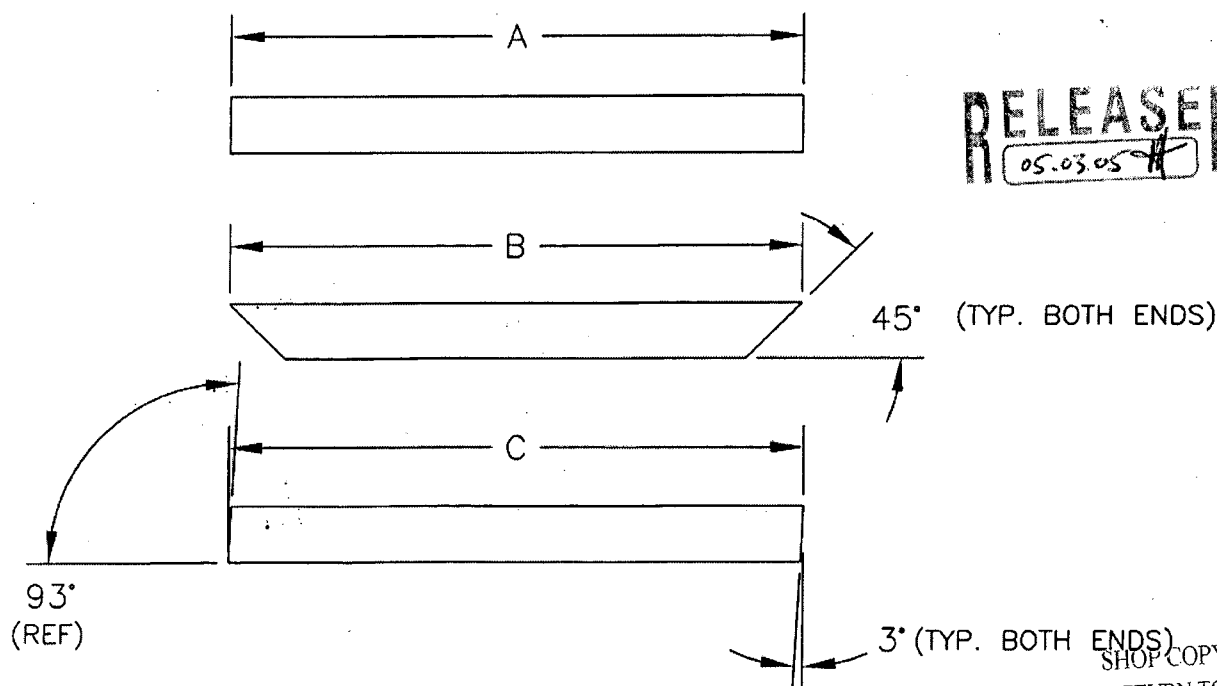
NOTE: Date & initial all entries



| | | | |
|------------------------|-------------------------|---|------------------------|
| DESIGN PH | DRAWN BY PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D3326 | REV. B SHEET 1 OF 3 |
| DATE 05.03.04 | | TITLE BASKET BASE ASSEMBLY | SCALE NTS |
| A | 04.10.21 | NEW ISSUE | |
| B | 05.03.04 | UPDATE TUBING AND MESH MAT'L SPEC | |

PARTS LIST FOR D3326-041 BASKET BASE ASSEMBLY

| Part No. | Quantity (-041) | Length A | Length B | Length C | Description |
|----------|-----------------|----------|----------|----------|------------------|
| D3326-1 | 1 | 14.00 | N/A | N/A | BOTTOM TUBE |
| D3326-3 | 4 | N/A | 56.50 | N/A | FULL LENGTH TUBE |
| D3326-5 | 2 | N/A | 16.00 | N/A | TOP END TUBE |
| D3326-7 | 2 | N/A | 15.00 | N/A | BOTTOM END TUBE |
| D3326-9 | 6 | N/A | N/A | 11.04 | VERTICAL TUBE |
| D3328-3 | 2 | N/A | N/A | N/A | HINGE PLATE |
| D3348-1 | 4 | N/A | N/A | N/A | CLEVIS |
| D3349-3 | 2 | N/A | N/A | N/A | SPACER BUSHING |
| D3367-1 | 2 | N/A | N/A | N/A | MOUNTING BRACKET |



D3326-1/-3/-5/-7/-9

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE PER MIL-T-6736, 1/2" SQ. x 0.035 WALL (REF. DART SPEC M4130-TS0.500W.035)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES.

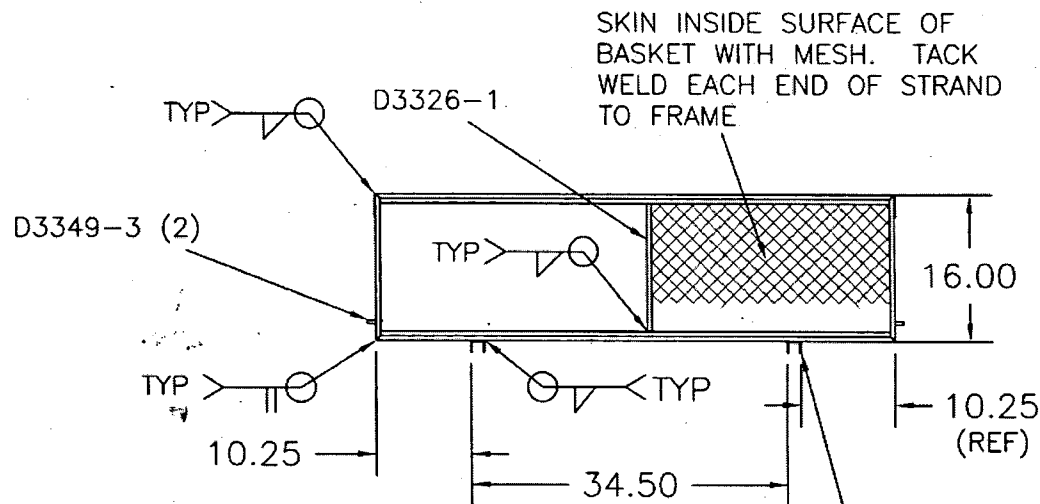
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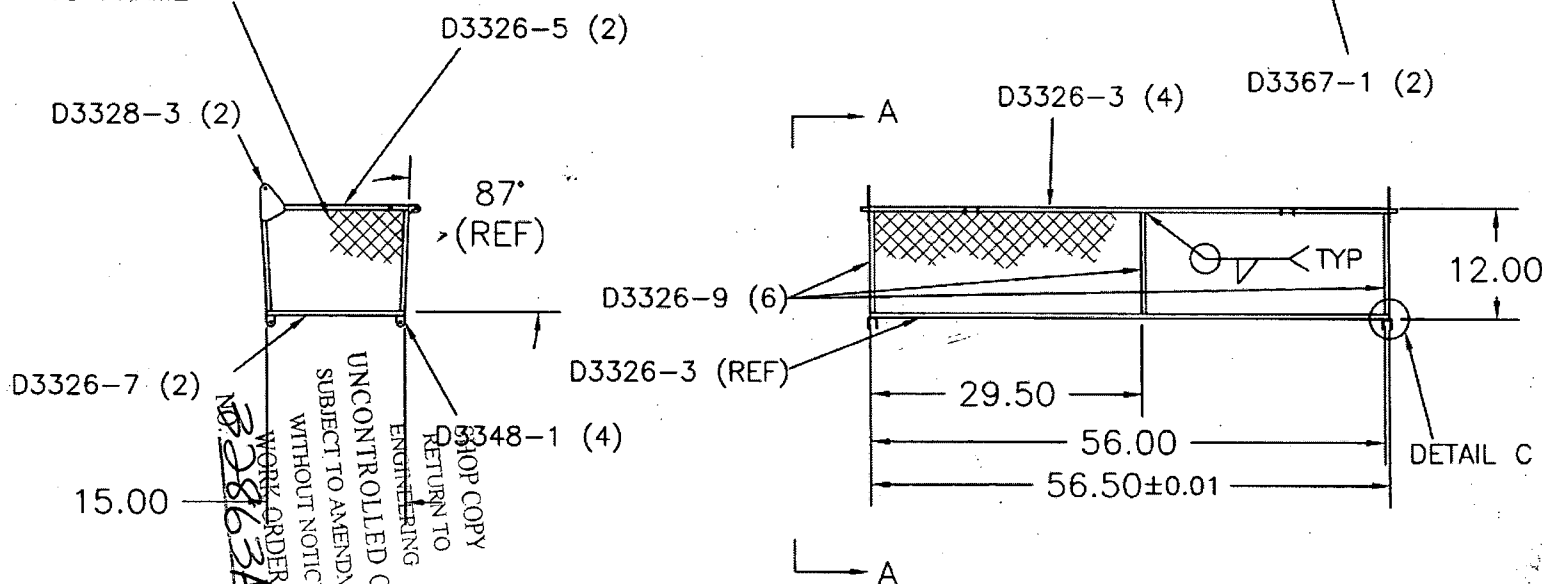
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| | | | | |
|---------|----------|----------|----------------------|-----------------------------|
| DESIGN | DH | DRAWN BY | DH | DART AEROSPACE LTD |
| CHECKED | DH | APPROVED | DH | HAMKESBURY, ONTARIO, CANADA |
| DATE | 05.03.04 | TITLE | D3326 | REV. B |
| | | | BASKET BASE ASSEMBLY | SHEET 2 OF 3 |
| | | | | SCALE 1:25 |



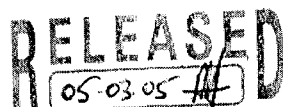
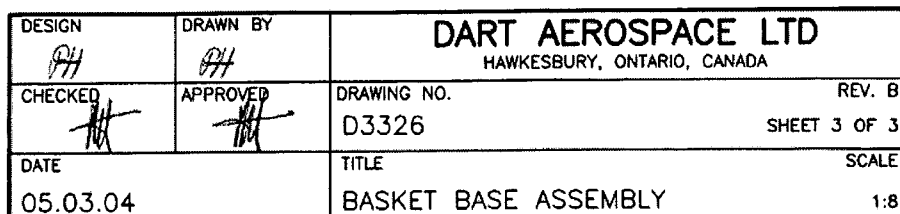
SKIN INSIDE SURFACE OF BASKET WITH MESH. TACK WELD EACH END OF STRAND TO FRAME



D3326-041 BASKET BASE ASSEMBLY

- 1) MESH MATERIAL: 1/2" - 18 GAUGE FLATTENED (0.040 THICK) EXPANDED CARBON STEEL (REF DART SPEC. M569EX0.50-18F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 4.0

RELEASED
05.03.05



VIEW A-A



D3348-1
(2 PER END, 4 TOTAL)



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26

Date: Thursday, 6/7/2007 3:32:01 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BASKET LID ASSEMBLY
 Job Number : 32863B
 Estimate Number : 11332
 P.O. Number : N/A Part Number : D3327041
 This Issue : 6/7/2007 S.O. No. : N/A Drawing Number : D3327 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : B
 Previous Run : 32862B Material : N/A
 Due Date : 6/26/2007 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : 07-06-08
 Comment : Est A 05.02.09 New issue KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M4130NTS0500W035 4130 Square tube .5 x .5



Comment: Qty.: 15.2250 f(s)/Unit Total : 15.2250 f(s)
 Material: 4130 Cond. N Square tube per MIL-T-6736,
 1/2" x 0.035" wall
 M4130N-TS0.500W.035) M19679

07/06/11

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
 1-Cut tubes as per Dwg D3327

| Qty | Part Number | Description | Batch |
|-----|-------------|------------------|--------|
| 2 | D3328-1 | Hinge Plate | B32846 |
| 2 | D3349-1 | Spacer Bushing | B32588 |
| 1 | D3352-1 | Label Plate | B28110 |
| 2 | D3367-1 | Mounting Bracket | B32478 |

Identify parts appropriately

2-Remove all markings from material and deburr as required.
 Check for foreign objects.

3-Drill and Weld as per Dwg D3327 & QSI 004
 A/RN/ASteel Rod M102226

4-Deburr as required

07/06/12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: R Date: 07/06/29
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 6/7/2007 3:32:01 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 32863B

Part Number: D3327041

Job Number:



Seq. #:

Machine Or Operation:

Description :

3.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-06-14 (1)

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 07-06-14 (1)

5.0

POWDER COATING

POWDER COATING



M104144



(1)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M-L 07/06/16

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 07/06/21

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SA

ml 07/06/21

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(1)
ml 07/06/21

Job Completion



U 07-06-28

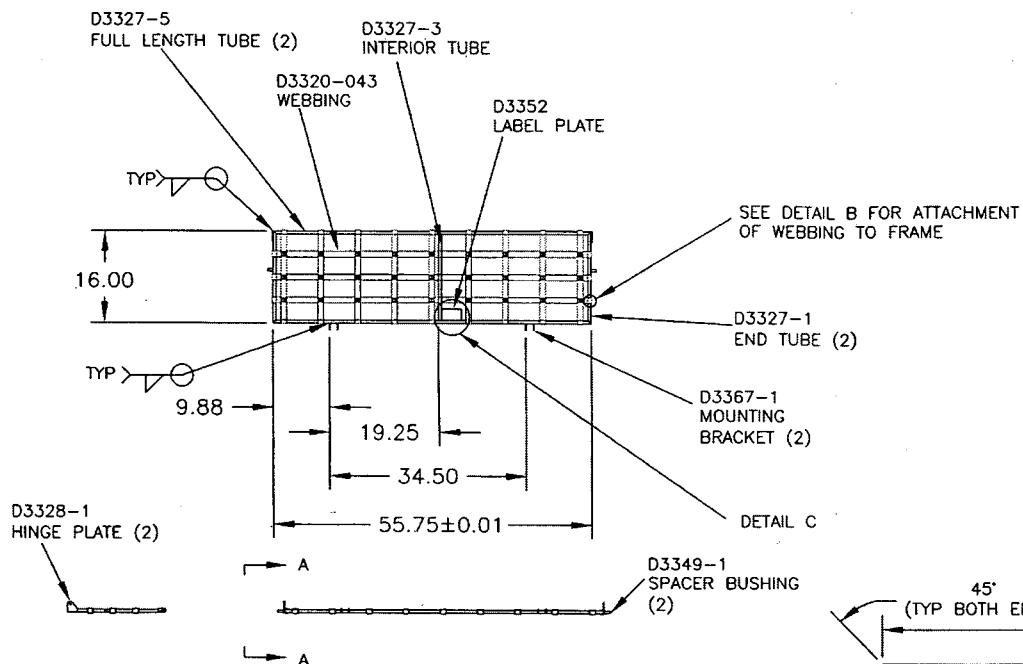
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

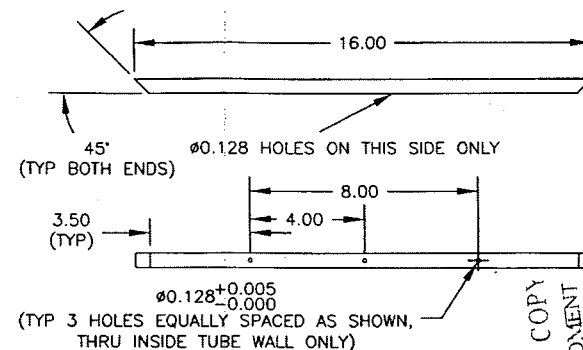


D3327-041 BASKET LID ASSEMBLY

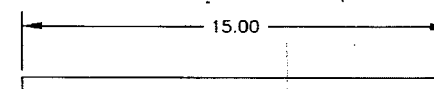
- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3 (PRIOR TO INSTALLATION OF D3320-043)
- 2) WELD PER DART QSI 004
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

PARTS LIST FOR D3327-041 BASKET LID ASSEMBLY

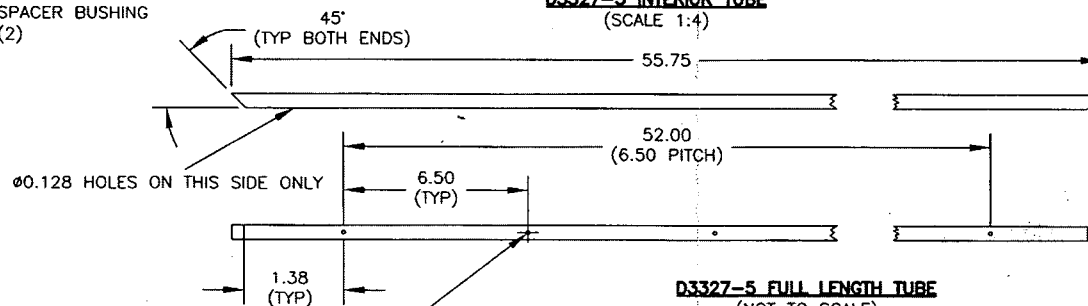
| Part No. | Quantity | Description |
|--------------|----------|------------------|
| D2729-1 | 1 | PART ID LABEL |
| D3320-043 | 1 | WEBBING |
| D3327-1 | 2 | END TUBE |
| D3327-3 | 1 | INTERIOR TUBE |
| D3327-5 | 2 | FULL LENGTH TUBE |
| D3328-1 | 2 | HINGE PLATE |
| D3349-1 | 2 | SPACER BUSHING |
| D3351-1 | 1 | PLACARD |
| D3352-1 | 1 | LABEL PLATE |
| D3367-1 | 2 | MOUNTING BRACKET |
| MS20600AD4W3 | 24 | RIVET |
| AN960JD9 | 24 | WASHER |



D3327-1 END TUBE
(SCALE 1:4)



D3327-3 INTERIOR TUBE
(SCALE 1:4)



D3327-5 FULL LENGTH TUBE
(NOT TO SCALE)

D3327-1/-3/-5

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N. SQ. TUBE, AMS-T-6736, 1/2" X 0.035 (REF. DART SPEC M4130N-TS0.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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| | | |
|---------|----------|--------------------------------|
| B | 05.04.25 | CHANGE RIVET AND HOLE DIAMETER |
| A | 04.10.21 | NEW ISSUE |
| DESIGN | PH | DRAWN BY PH |
| CHECKED | CH | APPROVED |
| DATE | 05.04.25 | TITLE |
| | | BASKET LID ASSEMBLY |
| | | REV. B |
| | | SHEET 1 OF 3 |
| | | SCALE |
| | | 1:20 |

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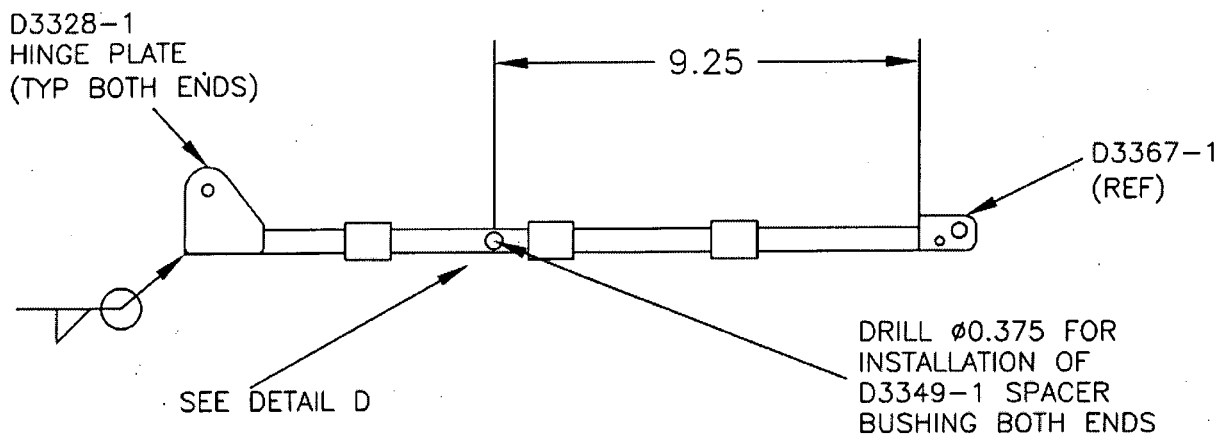
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05-10-2004

WORK ORDER
3286-3-100

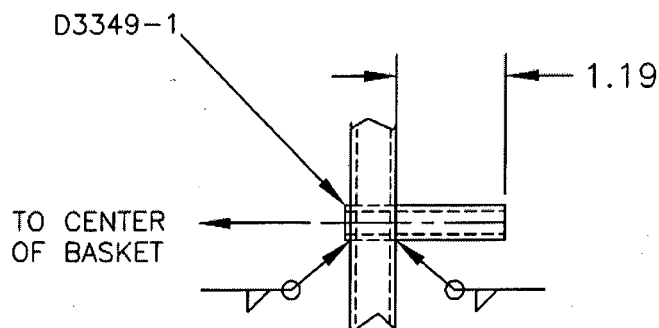
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3327 | REV. B SHEET 2 OF 3 |
| DATE 05.04.25 | | TITLE BASKET LID ASSEMBLY | SCALE 1:4 |



VIEW A-A



DETAIL D
(SCALE 1:2)

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05.04.28

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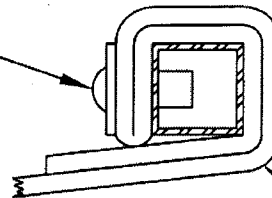
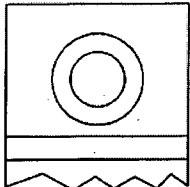
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3327 | REV. B SHEET 3 OF 3 |
| DATE 05.04.25 | TITLE BASKET LID ASSEMBLY | | SCALE 1:4 |

MS20600AD4W3 RIVET (1)
AN960JD9 WASHER (1)

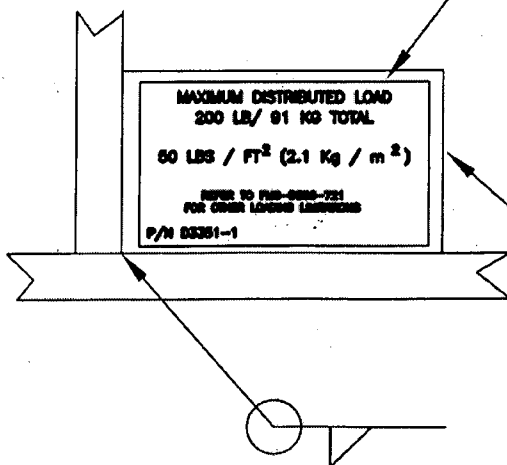


DETAIL B
TYP. ATTACHMENT OF WEBBING TO LID
FRAME
(SCALE 1:1)

D3320-043 WEBBING

RELEASED
05.04.28

ATTACH D3351-1 PLACARD
ON TOPSIDE OF D3352-1



D3352-1

OUTBOARD

IDENTIFY WITH DART P/N
D350-721-043 USING
D2729-1 PRODUCT ID LABEL
INSTALLED ON UNDERSIDE OF
D3352-1

DETAIL C
LABEL PLATE ATTACHMENT
(SCALE 1:2)

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